

Work Order ID 77931

December-22-11 2:44:43 PM

77931

Page 1

Item ID: D2803-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 22/12/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/12/22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2803	Rev B

100 Small Fab 0.00
100
 Small Fab Memo 0.00
 Small Fab Press D2805-1 and D2809 into arm as per Dwg D2803

Handwritten signature 12/01/06 (4)

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC Memo 0.00
 Quality Control

Handwritten signature 12-01-06 (4)

120 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00
120
 Powdercoat Memo 0.00
 Powder Coating START TIME: 9:50 OVEN TEMPERATURE:
 FINISH TIME: 3200 F 10:20

Handwritten signature 12/01/07

Handwritten note: m119480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130						(4)	(4)	12-01-07	
QC	Memo	0.00							
Quality Control									
150	Small Fab	0.00							
150									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D2803.								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00				(4)			
Quality Control									

EP 12/01/09 (4)

8.12.10.09

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>147</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

ME
 12-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 77931

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Parent Item: D2803-041

D2803-041

Parent Item Name: Bracket Assembly

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq-ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-1 *D2803-1* Bracket		Manufactured	No			100	Each	8.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST148				8					
				75079				8					
D2805-1 *D2805-1* Stop		Manufactured	No			100	Each	22.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				22					
				75242				12					
				76185				10					
NAS1515H3 *NAS1515H3* Washer		Purchased	No			100	Each	67.0000	4	16			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST277				67					
				116373				6					
				118078				6					
				118384				11					
				119438				44					

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**

**

12/01/06

12/01/06

12/01/06

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D2803-041

D2803-041

Parent Item Name: Bracket Assembly

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

AN3C16A

Purchased

No

150

Each

72.0000

2

8

AN3C16A

Bolt

**

EP 12/01/09

Location

Loc Qty

Loc Code

ST352

72

115835

1

118422

4

118628

25

119641

42

8

D2809

Manufactured

No

150

Each

35.0000

1

4

D2809

Bushing

**

EP 12/01/09

Location

Loc Qty

Loc Code

GA

7

72735

7

ST023

28

34035

12

77292

16

4

MS21043-3

Purchased

No

150

Each

1,469.000

2

8

MS21043-3

Nut

**

EP 12/01/09

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

750

119901

750

ST301

647

118077

2

118614

441

118686

30

119758

174

8

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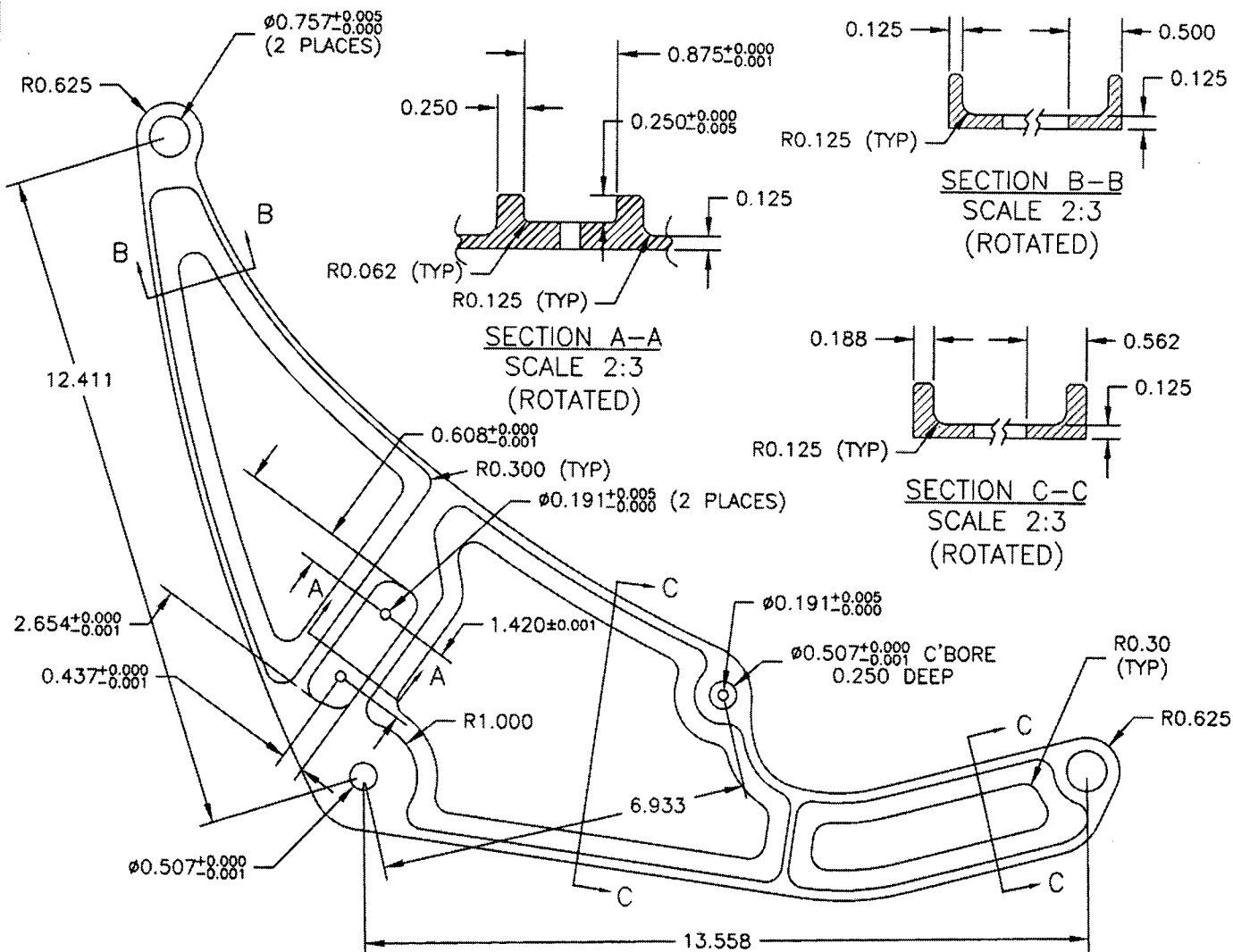
NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE	04.11.22			TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	

RELEASED

05.03.11



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 77931
M.L.S
11/12/22

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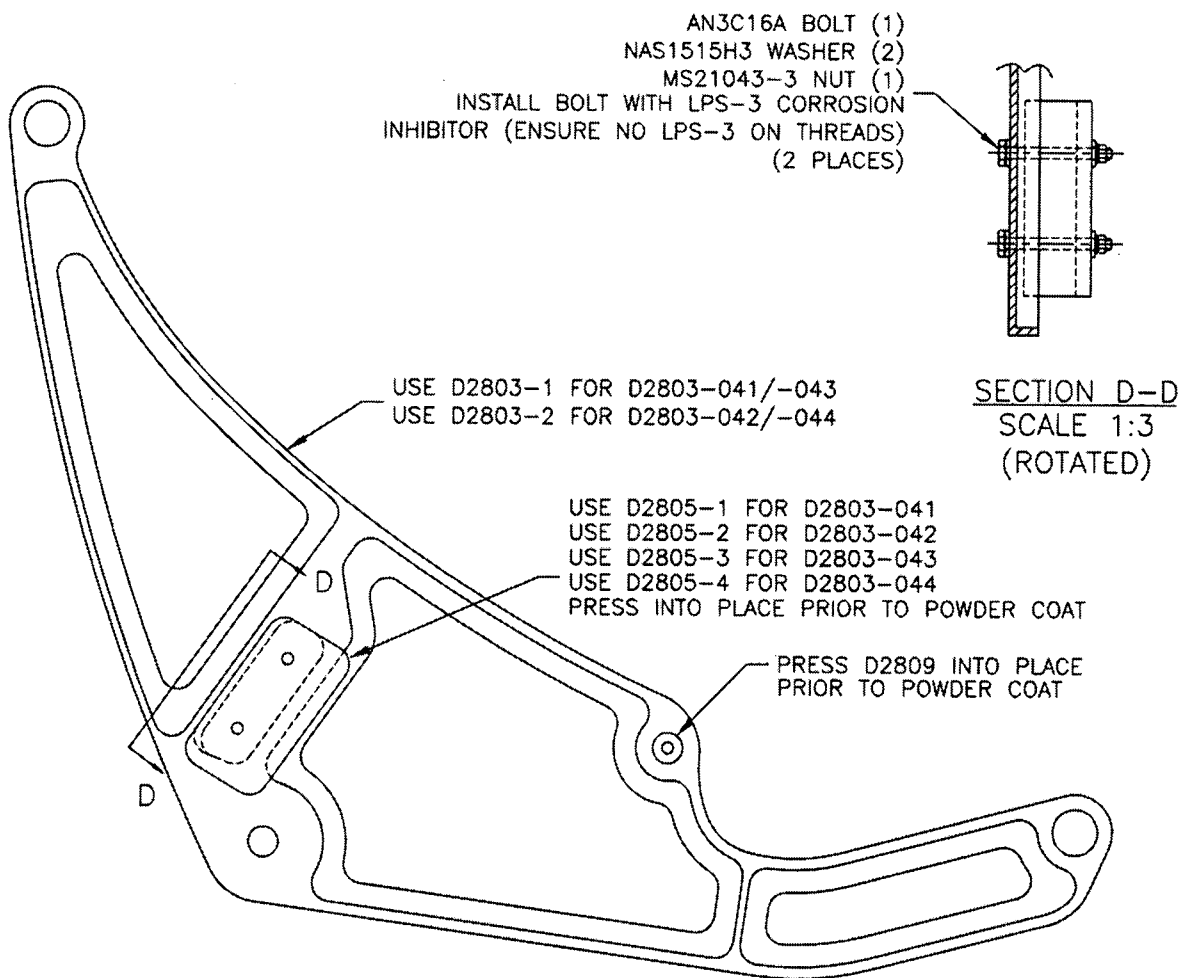
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03-11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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